

# Work Order ID 62150

Friday, September 17, 2010 1:39:14 PM

Page 1

Item ID: D2572

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd In 205

Start Date: 9/17/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. 62150

Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

OK 10/10/14

SL 10/10/04

12 0

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2571 & D2572

OK 10.10.14

12 0

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Page 2

Item ID:	D2572	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, Fwd In 205					
Start Date:	9/17/2010	Start Qty:	12.00		Cust Item ID:	
Required Date:	9/17/2010	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	SL 10/10/04 ml 10/10/14 ml 10.10.19			12	0		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	B.A. 10/10/20			12	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	=> M 10/10/20			12	0		

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Page 3

Item ID: D2572	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Fwd In 205					
Start Date: 9/17/2010	Start Qty: 12.00		Cust Item ID:		
Required Date: 9/17/2010	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115291</i>	0.00 <i>10-10-21</i>				<i>(12)</i>			
	Memo START TIME: <i>8:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>9:20</i>	0.00							
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 <i>10/10/21</i>				<i>120</i>			
		0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>433</i>  Memo	0.00 <i>10/10/21</i>				<i>(12)</i>			
		0.00							

**Work Order ID 62150**

Friday, September 17, 2010 1:39:14 PM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 9/17/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22 JG

MF

10-10-21

# Picklist Print

Friday, September 17, 2010 1:39:19 PM

Page 1

Work Order ID: 62150



Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205


Start Date: 9/17/2010

Required Date: 9/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated  
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005  Saddle Billet		Manufactured	No			100	Each	25.0000	1	12		09-16-10-19	

Location

MAT46

46411

Loc Qty

25

25

Loc Code

12

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>C2850</i>
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440	vern	SL-3
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	vern	CNC-02
F	0.490	0.510		.501	.501	.504	.503	vern	SL-3
G	0.257	0.262		.258	.260	.260	.260	"	"
H	0.375	0.380		.376	.377	.377	.377	"	"
I	0.490	0.510		.500	.500	.500	.499	"	"
J	1.174	1.184		1.179	1.177	1.178	1.179	"	"
K	0.558	0.578		.567	.570	.568	.568	"	"
L	1.174	1.184		1.179	1.177	1.178	1.179	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.874	3.874	3.872	3.873	"	"
P	0.115	0.135		.127	.128	.127	.128	mic	SL-4
Q	0.115	0.135		.130	.135	.135	.135	vern	SL-3
R	0.240	0.260		.250	.250	.250	.250	"	"
S	0.115	0.135		.129	.129	.129	.130	deep	mic 118-120
T	0.178	0.198		.188	.188	.188	.188	R-G	"
U	2.940	2.980		2.960	2.960	2.960	2.960	vern	SL-3
V	0.230	0.250		.237	.235	.237	.238	"	"
W	0.115	0.135		.126	.128	.128	.130	deep mic	118-120
X	0.307	0.312		.312	.311	.312	.310	vern	ML-7
Y	0.760	0.765		.766	.760	.760	.760	"	"
Z	0.352	0.372		.363	.364	.364	.364	vern	SL-3
AA	0.470	0.530		.500	.500	.500	.500	R-G	"
AB	0.615	0.635		.623	.626	.625	.627	vern	SL-3
AC	0.053	0.073		.063	.063	.063	.063	R-G	"
AD	0.240	0.260		.247	.245	.245	.243	vern	SL-3
AE	1.375	1.395		1.392	1.391	1.389	1.397	dial	"
AF	0.115	0.135		.135	.135	.135	.135	vern	SL-3
AG	0.240	0.280		.260	.260	.260	.260	"	"
AH	0.240	0.260		.246	.243	.245	.245	"	"
AI	2.000	2.020		2.006	2.007	2.005	2.007	dial	"
AJ	0.023	0.043		.030	.030	.030	.030	vern	SL-3
Accept/Reject									

Measured by:	SL	<i>9ml</i>
Date:	10/10/04	10/10/14

Audited by:	B.A.
Date:	10/10/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <i>CA250</i>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
A	0.438	0.443		.440	.440	.440	.440	Vern	ML-7
B	1.745	1.755		1.750	1.750	1.750	1.750	"	
C	3.495	3.505		3.500	3.500	3.500	3.500	"	
D	1.745	1.755		1.750	1.750	1.750	1.750	Vern	CNC-02
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	ML-7
F	0.490	0.510		.500	.500	.502	.502	Vern	ME-7
G	0.257	0.262		.260	.260	.260	.260	"	"
H	0.375	0.380		.377	.377	.377	.377	"	"
I	0.490	0.510		.490	.499	.500	.500	"	"
J	1.174	1.184		1.179	1.179	1.178	1.178	"	"
K	0.558	0.578		.569	.569	.569	.569	"	"
L	1.174	1.184		1.179	1.179	1.178	1.178	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.873	3.872	3.873	3.874	"	"
P	0.115	0.135		.127	.128	.127	.127	Micr	118-120
Q	0.115	0.135		.135	.135	.135	.135	Vern	ML-7
R	0.240	0.260		.260	.250	.250	.250	"	"
S	0.115	0.135		.130	.130	.132	.130	Micr	118-120
T	0.178	0.198		.188	.188	.188	.188	Refuge	REF
U	2.940	2.980		2.960	2.960	2.960	2.960	Vern	ML-7
V	0.230	0.250		.236	.235	.238	.236	"	"
W	0.115	0.135		.132	.130	.130	.130	Micr	118-120
X	0.307	0.312		.311	.310	.310	.310	Vern	ML-7
Y	0.760	0.765		.760	.760	.760	.760	"	"
Z	0.352	0.372		.365	.364	.365	.365	"	"
AA	0.470	0.530		.500	.500	.500	.500	R-6	ref.
AB	0.615	0.635		.625	.626	.626	.626	Vern	ML-7
AC	0.053	0.073		.063	.063	.063	.063	R-6	ref.
AD	0.240	0.260		.243	.243	.241	.245	Vern	ML-7
AE	1.375	1.395		1.390	1.390	1.390	1.390	Vern	ML-7
AF	0.115	0.135		.135	.135	.135	.135	"	"
AG	0.240	0.280		.260	.260	.260	.260	"	"
AH	0.240	0.260		.244	.246	.246	.245	"	"
AI	2.000	2.020		2.006	2.006	2.006	2.006	dial	
AJ	0.023	0.043		.030	.030	.03	.03	Vern	ML-7

Accept/Reject

Measured by: <i>ML</i>
Date: <i>10/10/14</i>

Audited by: <i>H.A</i>
Date: <i>10/10/20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <i>C2850</i>
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440	Vern	ML-7
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CNC-02
F	0.490	0.510		.500	.500	.500	.500	"	ML-7
G	0.257	0.262		.260	.260	.260	.260	"	"
H	0.375	0.380		.377	.377	.377	.377	"	"
I	0.490	0.510		.498	.500	.500	.500	"	"
J	1.174	1.184		1.178	1.178	1.178	1.178	"	"
K	0.558	0.578		.568	.568	.568	.568	"	"
L	1.174	1.184		1.178	1.178	1.178	1.178	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.500	2.500	2.500	2.500	"	"
O	3.869	3.879		3.873	3.874	3.874	3.874	"	"
P	0.115	0.135		.128	.128	.128	.128	Micr	118-120
Q	0.115	0.135		.135	.135	.135	.135	Vern	ML-7
R	0.240	0.260		.251	.260	.258	.258	"	"
S	0.115	0.135		.132	.132	.132	.132	Micr	118-120
T	0.178	0.198		.188	.188	.188	.188	Rad	gag
U	2.940	2.980		2.960	2.960	2.960	2.960	Vern	ML-7
V	0.230	0.250		.235	.235	.235	.235	"	"
W	0.115	0.135		.130	.130	.130	.130	Micr	118-120
X	0.307	0.312		.310	.310	.310	.310	Vern	ML-7
Y	0.760	0.765		.760	.760	.760	.760	"	"
Z	0.352	0.372		.365	.365	.365	.365	"	"
AA	0.470	0.530		.500	.500	.500	.500	Rad	gag
AB	0.615	0.635		.627	.627	.627	.627	Vern	ML-7
AC	0.053	0.073		.063	.063	.063	.063	Rad	gag
AD	0.240	0.260		.246	.246	.246	.246	Vern	ML-7
AE	1.375	1.395		1.391	1.390	1.390	1.390	"	"
AF	0.115	0.135		.135	.135	.135	.135	Vern	ML-7
AG	0.240	0.280		.260	.260	.260	.260	"	"
AH	0.240	0.260		.245	.245	.245	.245	"	"
AI	2.000	2.020		2.007	2.007	2.007	2.007	"	"
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	ML-7





Measured by: <i>[Signature]</i>	Audited by: <i>H.A</i>
Date: <i>10.10.19</i>	Date: <i>10/10/20</i>

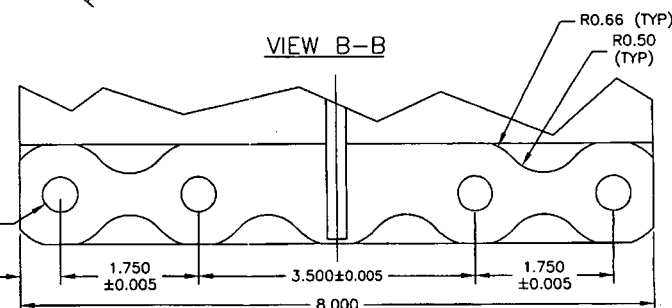
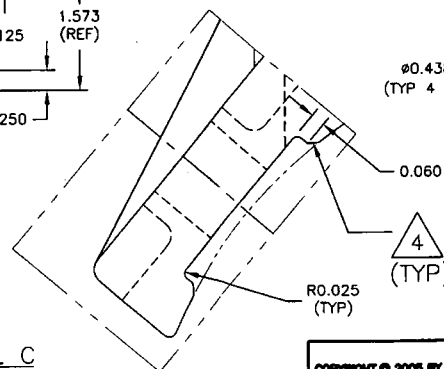
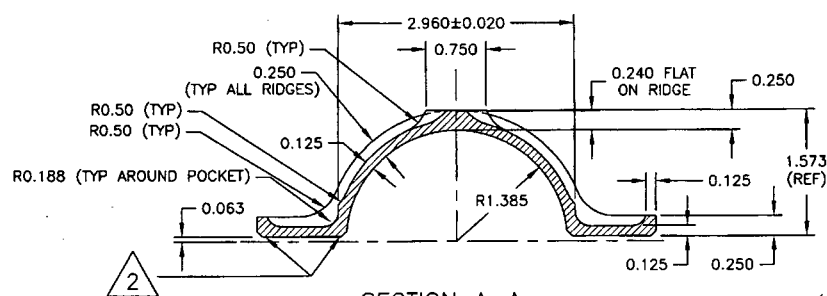
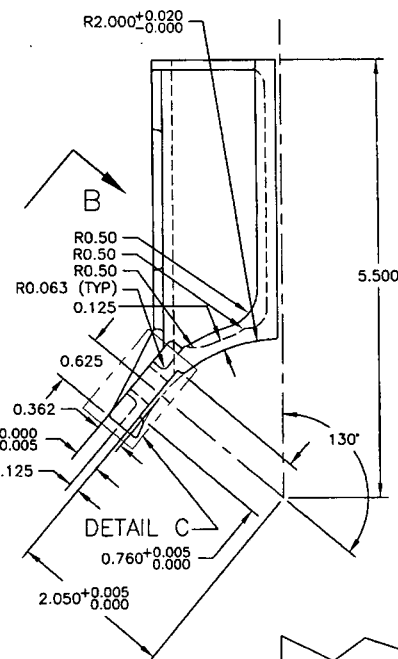
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>



NO. 02150 05.12.06 11  
010917




MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |                                                                                     |                                                                  |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
			
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED	
		DRAWING NO.	REV.
		D2572	SHEET 1 OF
DATE		TITLE	SCALE
05.07.13		INNER FWD SADDLE	2